Work Order ID 97358 *97358* Page 1 Friday, February 15, 2013 3:06:39 PM D3935-4 Item ID: Accept *N900040100* Setup Start **Revision ID:** Item Name: Pylon Wall Protector, RH Stop **Start Date:** Start Qty: 4.00 *4* 2/15/2013 **Cust Item ID:** Required Date: 2/22/2013 Req'd Qty: 4.00 **Customer:** Reference: Date: 13-2-19 Tooling: Process Plan: Approvals: Date: QC: Date: **SPC (Y/N):** Date: Sequence ID/ Operation Set Up/ Reject Tool ID Tool # Plan Accept Reject Insp. Work Center ID **Description Run Hours** Code Qty Qty Number Stamp **Draw Nbr Revision Nbr** D3935 В 100 0.00 *100* Waterjet 0.00 Memo FLOW CNC Waterjet 1-Cut as per Dwg D3935 Dwg Rev: Prog Rev: 2- Deburr if necessary 110 QC2- Inspect parts off machine FAI/FAIB 0.00 *110* JM13-2-21 OC

0.00

Memo

Quality Control

NCR:	res / No				WORK ORDER NON-C	O	NFORN	/IANCE / UPDAT	E					
										QA Closed:	Date:			
Work Orde	ar.				DISPOSITION		AGAINST DEPARTMENT/PROCESS							
WOIK OIG					Rework	1		Skid-tube Cro	osstube		Water Jet	Engineering		
Part N	No.				Scrap	1 1	1		nall Fab	Pro	d. Eng. Coor.	Quality		
					Use-as-is	1 1	•	~	inishing		e/Packaging	Other		
NCR I	No				Work Order Update]		Large Fab Cor	mposite		Supplier			
Root				Descri	ption of work order update		Initial	Action		Sign &				
Cause	Date	Step	Qty	(or Non-conformance	Ch	nief Eng	Description	n	Date	Verification	QC Inspector		
Doc/Data	Ш	1					ļ							
Equip/Tooling						Ì	Ì				•			
Operator														
Material							1							
Setup														
Other														
Process			,											
Supplier														
Training														
Unapproved		<u> </u>		L				<u> </u>						
					F.	AUL	T CATE	GORY						
Landi	ng Gear			_	General		1			1	_	٦		
	Bending				Bend		Grain		ļ	Ovalized	ļ	Pressure/Forced		
	Centre I	Not Conce	ntric to	o/s	BOM/Route		Hardwa	re		Over/Under		Temperature/Cure		
:	Cracks				Broken/Damaged		Inspecti	on Incomplete		Part Incorre		Weld		
	Crushed	/Crimped			Burrs		Instruct	ions incomplete/Unclea	ar	Part Lost/M	ssing	Wrong Stock Pulled		
	Cuffs				Contamination		Mainte		<u> </u>	Part Moved				
	Heat Tro	eat			Countersink		Mislabe	led	<u> </u>	Positioned V	Vrong	¬		
	Inspecti	on Strip in	Tube		Cut Too Short		Misread	I		Power Loss/	Surge	Other		
	Rinnles	in Rend		[Drill Holes	1	Offset							

Out of Calibration

Out of Sequence

Outside Dimensions

DQA:

Date:

Turning Sequence

Wave/Twist in Tube

Torque Waves in Extrusion

Drawing

Finish

Folio

Work Order ID 97358 *97358* Page 2 Friday, February 15, 2013 3:06:39 PM D3935-4 Item ID: Accept *N900040100* Setup Start **Revision ID:** Item Name: Pylon Wall Protector, RH 2/15/2013 **Start Date:** Start Oty: 4.00 **Cust Item ID:** Required Date: 2/22/2013 **Reg'd Oty:** 4.00 **Customer:** Reference: Run Start Process Plan: Date: Tooling: **Approvals:** Date: Stop QC: ____ Date: ____ SPC (Y/N): Date: Sequence ID/ Operation Set Up/ Tool ID Tool # Plan Accept Reject Reject Insp. Work Center ID Description **Run Hours** Code Qty Qty Number Stamp 120 QC8- Inspect parts - second check 0.00 *120* Memo Quality Control 130 Identify as per dwg & Stock Location:_ 0.00 *130* Packaging Memo Packaging 140 QC21- Final Inspection - Work Order Release 0.00 *140* 0.00 Memo Quality Control

11/20232

DQA: _____ Date: ____

1	'es	/ No				WORK ORDER NON-O	CON	1FORN	//ANCE / UP	DATE				
		•									QA Closed:	Dat	e:	
k Orde	ır.					DISPOSITION		AGAINST DEPARTMENT/PROCESS						
ik Orac						Rework	1	Skid-tube Crosstube			1	Water Jet	Engineering	
Part N	lo.					Scrap	1		Machining	Small Fab	Proc	d. Eng. Coor.	Quality	
	•					Use-as-is]	Therm	noforming	Finishing	Rec/Stor	e/Packaging	Other	
NCR N	lo.	······································				Work Order Update]		Large Fab	Composite]	Supplier		
Root					Descri	ption of work order update		nitial	Ac	tion	Sign &			
ause		Date	Step	Qty		or Non-conformance	Ch	ief Eng	Desc	ription	Date	Verification	QC Inspector	
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/Tooling							ŀ							
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Lanui		Bending				Bend		Grain			Ovalized	ſ	Pressure/Forced	
	_	Centre No	t Concer	ntric to (_{2/5}	BOM/Route	\vdash	Hardwa	re	-	Over/Under	tolerance	Temperature/Cure	
		Cracks	Conce	10100	³ , –	Broken/Damaged			on Incomplete		Part Incorred	ł	Weld	
		Crushed/C	rimned			Burrs	\vdash		ions Incomplete,	/Unclear	Part Lost/Mi	†	Wrong Stock Pulled	
	$\overline{}$	Cuffs	impea.		-	Contamination		Mainte	•		Part Moved	,		
	\dashv	Heat Treat Countersink					Mislabe			Positioned V	Vrong			
				Cut Too Short		Misread			Power Loss/	r	Other			
		Ripples in				Drill Holes		Offset		<u> </u>				
		Torque W		xtrusio	,	Drawing		Out of Calibration						
		Turning Se				Finish		Out of S	equence					
		Wave/Twi		e		Folio		Outside	Dimensions					

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Page

Work Order ID:

97358

Parent Item:

D3935-4

Parent Item Name:

Pylon Wall Protector, RH

Start Date: 2/15/2013

Required Date: 2/22/2013

Start Qty: 4.00

Required Qty: 4.00

Comments:

IPP RevA: New issue DD verified by:EC

													•
Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
MLEXS.125-F60029-04		Purchased	No			100	sf	0.0000	8.048	22 0042			
GE PLASTICS LEXAN SH	HEET	ı ur urusuu						0.0000	0.040	250003 254	6		ImB:

124654

124654

Yes ,	/ No
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DQA: _____ Date: ____

Ye	s / No					WORK ORDER NON-C	.UI	VEORI	VIAINCE / UPI	DA1E	QA Closed:	Dat	e:	
k Order	•					DISPOSITION		AGAINST DEPARTMENT/PROCESS						
Part No						Rework Scrap Use-as-is Work Order Update			Skid-tube Crosstube Machining Small Fab Thermoforming Finishing Large Fab Composite			Water Jet d. Eng. Coor. e/Packaging Supplier		Engineering Quality Other
oot		Ī		Desc	crip	otion of work order update		nitial	Act	tion	Sign &			
use	Date	Step	Qty		0	r Non-conformance	Ch	ief Eng	Descr	ription	Date	Verification		QC inspector
Data /Tooling ator rial or cess lier ing														
		<u> </u>	1	L		F.A	AUL	T CATE	GORY		- 			
Landing	Gear			······································		General								
	Bending Centre Not Concentric to O/S Cracks Crushed/Crimped. Cuffs Bend BOM/Route Broken/Damaged Burrs Contamination				BOM/Route Broken/Damaged Burrs Contamination		Inspecti Instruct Mainte	Grain Hardware Inspection Incomplete Instructions Incomplete/Unclear Maintenance		Ovalized Over/Under tolerance Part Incorrect Part Lost/Missing Part Moved			Pressure/Forced Temperature/Cure Weld Wrong Stock Pulled	
L	Heat Treat Countersink					<u> </u>	Mislabe		-	Positioned V	, ,		Other	
_	Inspection Strip in Tube Cut Too Short					Misread	I	L	Power Loss/	Surge]	Other		
-	Ripples in Bend Drill Holes Torque Waves in Extrusion Drawing					\vdash	Offset Out of Calibration							
-	Torque V Turning S			n j		Drawing Finish	-	Out of Sequence						
-		•		}		Folio		4	Dimensions					
1	Wave/Twist in Tube Folio							<u> </u>						

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DART AEROSPACE LTD	Work Order:	17358
Description: Pylon Wall Protector, RH	Part Number:	D3935-4
Inspection Dwg: D3935 Rev: B		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

X First Article	Prototype
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Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
5.68	+/-0.030	5.68"	 -		V	Jkmoi
12.68	+/-0.030	12.68"	-		-	Jkm06
18.75	+/-0.030	18.75"	_		ナ	
19.00	+/-0.030	19.00"	-		1	
20.25	+/-0.030	20.25	_		T	- Y
22.75	+/-0.030	22.35"	-		T	
23.73	+/-0.030	23.73	_		T	
28.63	+/-0.030	28.63"	-		-	
32.75	+/-0.030	32.35"			+	
1.00	+/-0.030	1,00			V	
3.50	+/-0.030	3,50"	-		V	
9.00	+/-0.030	9,00"	_		V	Productos
14.70	+/-0.030	14.70"	-		1	
16.20	+/-0.030	16.2011	٧		T	*
33.40	+/-0.030	3340	-		T	*, ,
34.25	+/-0.030	34.25"			 テ	*********
34.60	+/-0.030	34.60"	-		T	
34.72	+/-0.030	34.72	1		T	••
22.85	+/-0.030	22.85"	1		T	
19.15	+/-0.030	19.15"	1		T	
35.39	+/-0.030	35.39	-		T	
0.125	+/-0.010	0.126"	_		V	
			2AQ			

Measured by: Jm	Audited by:	95	Prototype Approval:	N/A
Date: 13-2-21	Date:	125.91	Date:	N/A

R	ev Date	Change	Revised by	Approved
	A 09.11.1	7 New Issue	KJ 🕏	1/1

